

Date: Friday, 16/01/2009 10:01:33 AM
 User: Julie Dawson

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	350/212/130 BASKET LID
Job Number :	44873B		
Estimate Number :	10193		
P.O. Number :		Part Number :	D2512
This Issue :	16/01/2009	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2512 REVE
First Issue :	1/1	Project Number :	N/A
Previous Run :	43785B	Drawing Revision :	E
	Type :	Material :	
	LARGE FAB ASSY	Due Date :	26/01/2009
Written By :		Qty:	1 Um: Each
Checked & Approved By :	<u>JLD 09.01.16</u>		
Comment :	Rev Est:M 03.01.31 Added D2012-117 for D130-701-041 KJ/ RF Est Rev:N 06.04.05 Added level21 EC Est Rev:O 08-08-29 revE as per dwg DD verified by:EC Est Rev:P 08-09-24 plug holes prior to powder coating DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W
-----	----------------	---------------------------



Comment: Qty.: 45.7594 f(s)/Unit Total: 45.7594 f(s)

Pick:

3/4"x3/4" 304/316 SS tube .065" wall

Batch:

M110561 15.92
 M110011 17.6846
 M110335 12.159

SAD 09-01-22 (P)

2.0	D31663	Basket Hoop
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Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3166-3	Basket Hoop	B44051 → 1x

SY 09/01/22

3.0	D2506	Label Plate
-----	-------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D2506	Label Plate	B39457 → 1x

SY 09/01/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/01/2009 10:01:33 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 44873B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D23271

Spacer Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2327-1 Bushing

Batch

B40390 → 2x

SY 09/01/30

5.0

D22321

Basket Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2232-1 Hinge plate

Batch

B39454 → 2x

SY 09/01/30

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description
2 D2581 Mounting Bracket

Batch

B43800 → 2x

SY 09/01/30

7.0

M304EX07516F

Expanded Metal Flat SS



Comment: Qty.: 18.0000 sf(s)/Unit Total : 18.0000 sf(s)

Pick:

Qty Part Number Description
18 sf M304EX0.75-16F Expanded Metal

Batch

M11D292

SY 09/02/02

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512 ✓

2-Cut (4) D2236 From D3166-3 ✓

3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305 ✓

5-Weld as per Dwg D2512 using Welding Table and corner Jig Deburr as required ✓

*PD 09-02-02
SY 09/02/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Date: Friday, 16/01/2009 10:01:33 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/212/130 BASKET LID

Job Number: 44873B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

9.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Cpl 09.02.03

10.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 02/02/03 (1)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

m109996

1- Plug holes in D2581 and in D2327-1 bushing prior to powder coating

2- Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1ST COAT:

START TIME:

8:45

OVEN TEMPERATURE:

400°

FINISH TIME:

9:15

(1)

2ND COAT:

START TIME:

9:20

OVEN TEMPERATURE:

400°

FINISH TIME:

9:50

UND / FL 09/02/04

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4

Spray paint: m10211

WW Batch: m109917

MD / FL 09/02/04

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-04

(1)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPR 44873

1-9/4/5 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Drawing Name: 350/212/130 BASKET LID

Job Number: 44873B

Part Number: D2512

Job Number:



Seq. #:

Machine Or Operation:

Description :

15.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/06 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-02-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

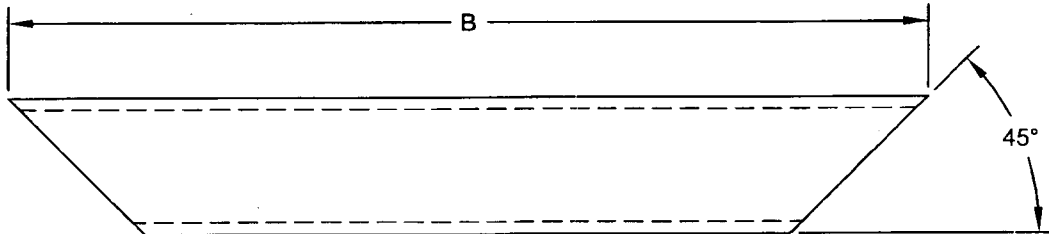
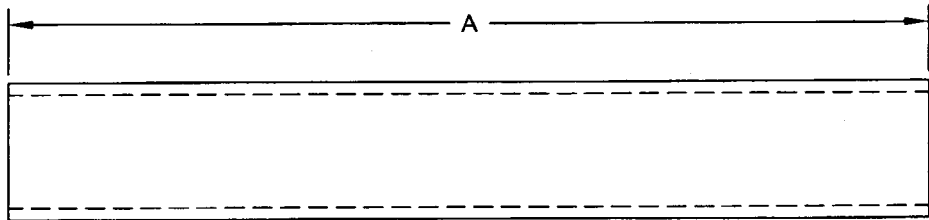
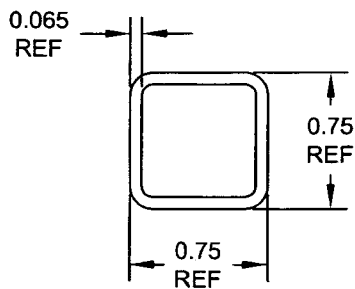
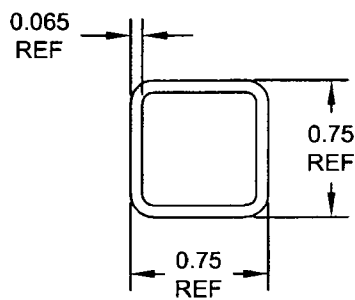
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



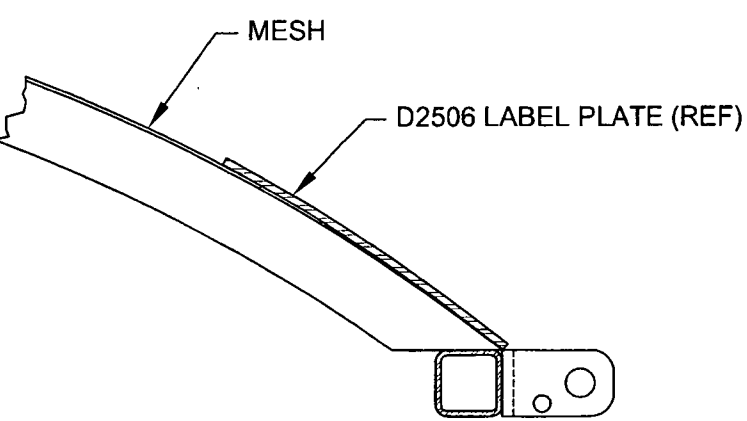
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WORK ORDER
NO. **W48738**

RELEASED
08-08-21/11

E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

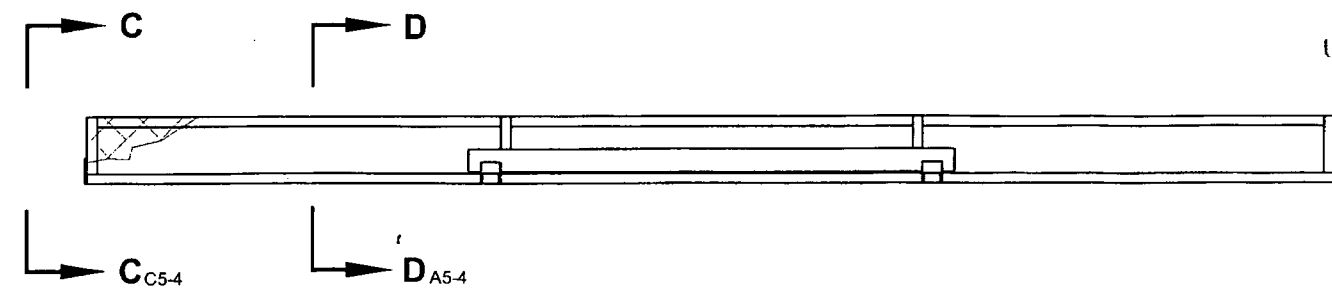
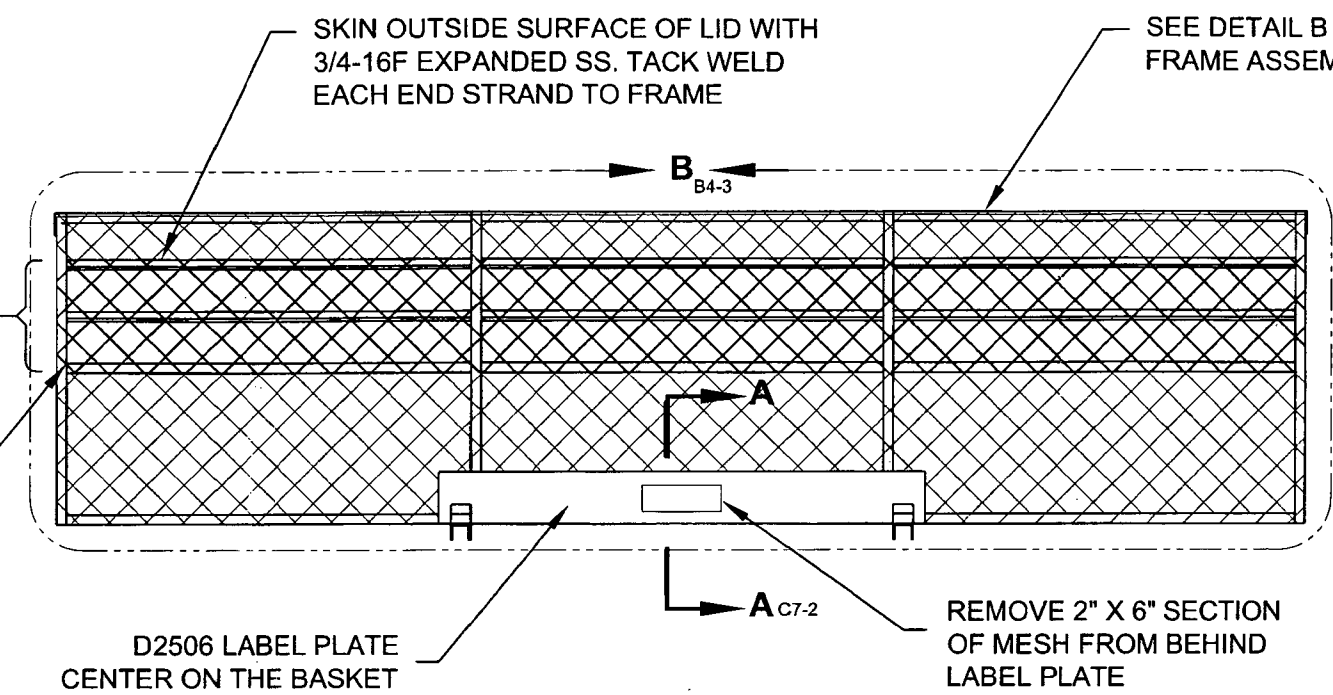


- D2512-1/-3/-5/-7 NOTES:**
- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST



FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



E

- D2512 BASKET LID ASSEMBLY NOTES:**
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
 - 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
 - 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
 - 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) BREAK SHARP EDGES: N/A
 - 7) IDENTIFICATION: NONE
 - 8) WEIGHT: N/A
 - 9) WELD PER DART QSI 004

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WORK ORDER
NO. 44873A

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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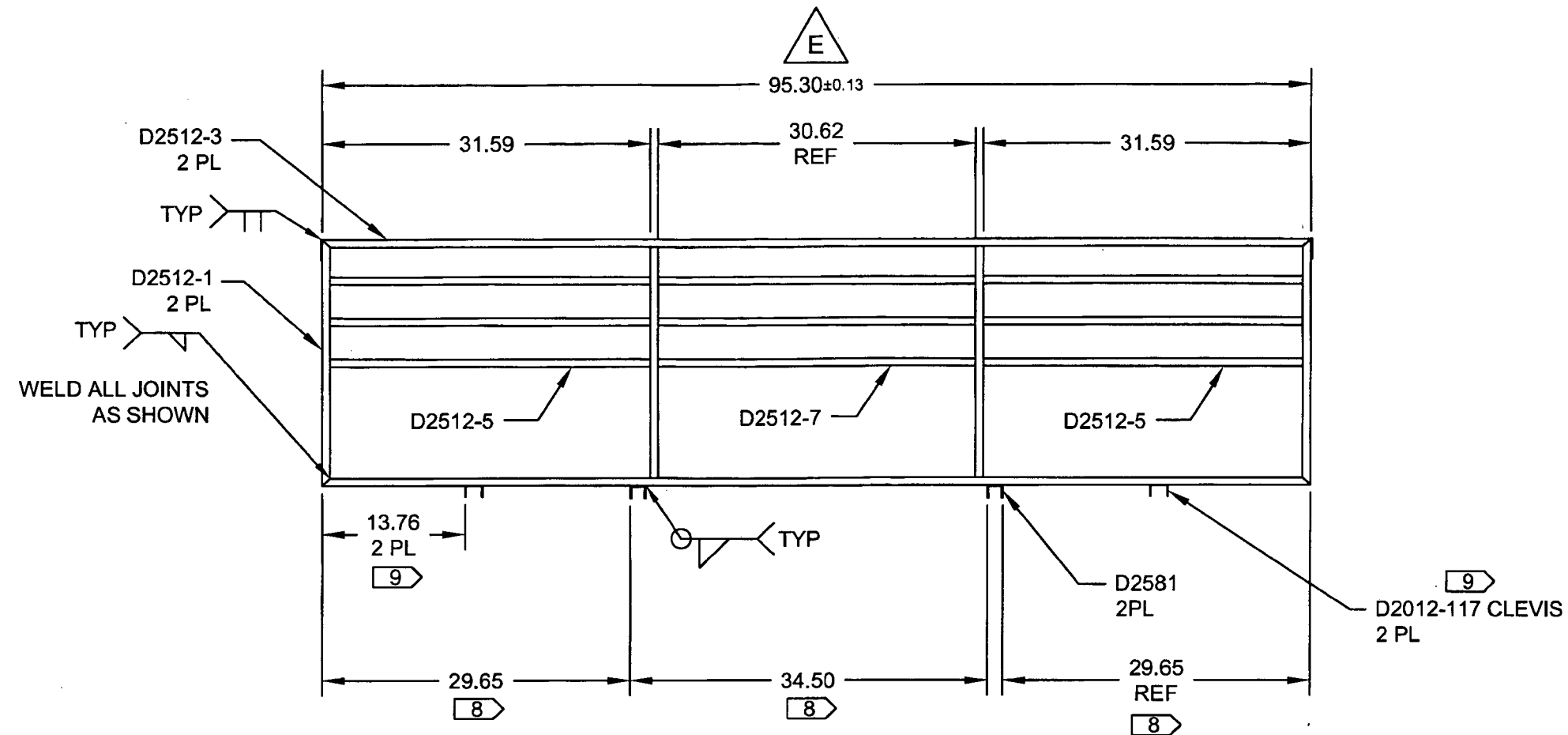
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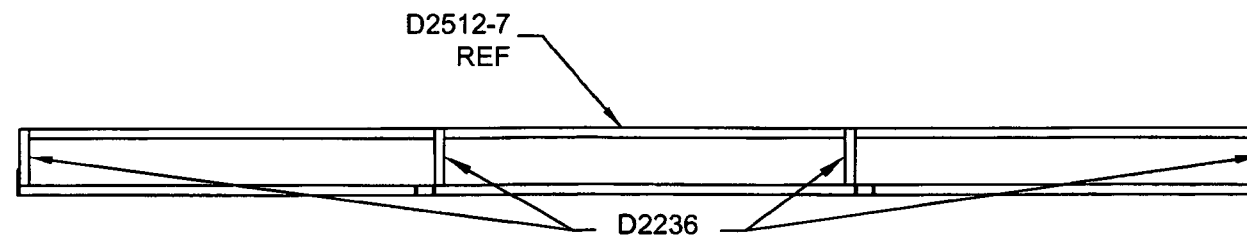
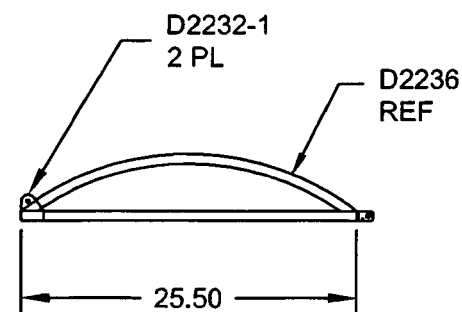
C

B

A



DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR
CLARITY



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44873A

RELEASED
08-06-17

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
- 9) FOR D130-701-041 ONLY

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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8 7 6 5 4 3 2 1

8

7

6

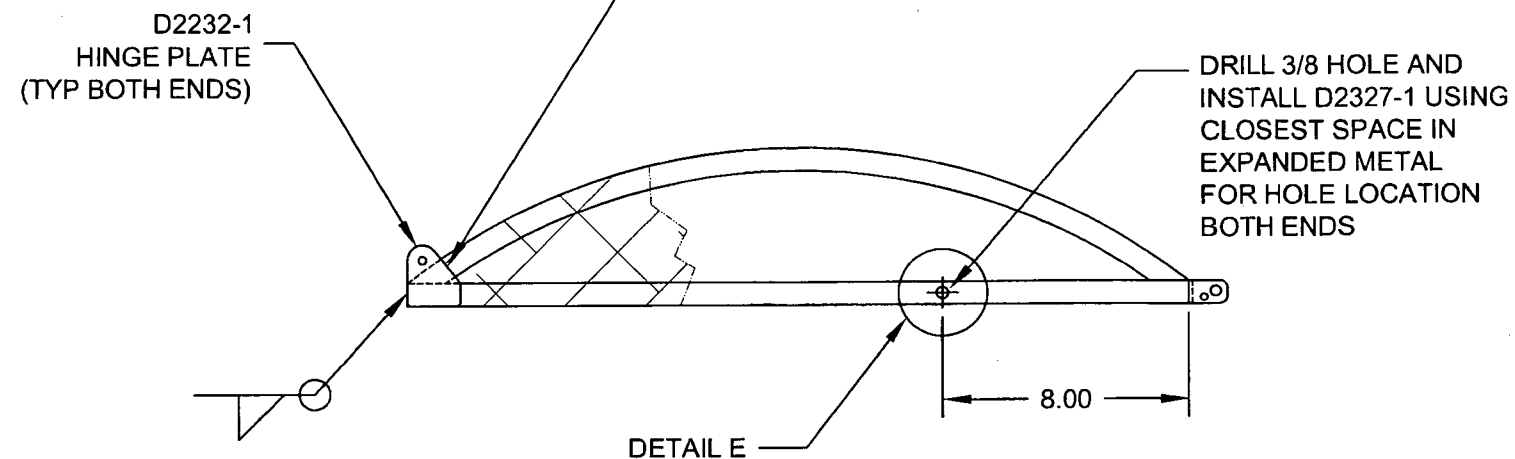
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4

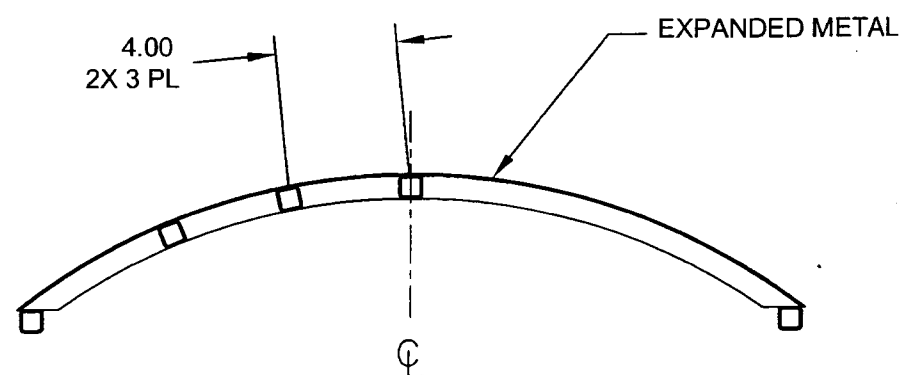
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2

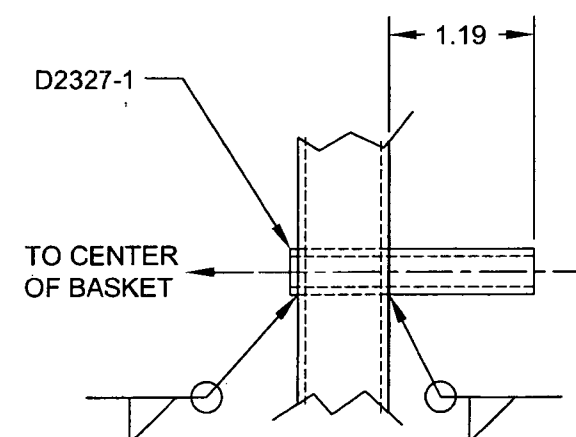
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VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

RELEASED

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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